

Work Order ID 70927

Friday, June 17, 2011 2:23:59 PM



Page 1

Item ID: D3198-1

Accept



Setup Start



Revision ID:

Item Name: Fitting

Stop



Start Date: 6/17/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 11/06/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3198

Rev A

100



FLOW WATER JET

Waterjet

Memo

0.00

B11-6-21

FLOW CNC Waterjet

304 . 105

1-Cut as per Dwg D3198

 Dwg Rev: A Prog Rev: A 2-

Deburr if necessary

(8)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

B11-6-21

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

C. Wach/21

QC

Memo

0.00

Quality Control

(X8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Setup

Start



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Start Date: 6/17/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC3- Inspect Part Finish

0.00

8

6

11/06/22

QC

Quality Control

170



Identify as per dwg & Stock Location:

246A

0.00

11/06/22 SF 80

Packaging

Packaging

180



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

11/06/23 JJ

ME
11-06-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

Picklist Print

Friday, June 17, 2011 2:24:05 PM

Page 1

Work Order ID: 70927



Parent Item: D3198-1



Parent Item Name: Fitting

Start Date: 6/17/2011

Required Date: 6/30/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: A□03.11.11□New Issue□KJ/RF□
IPP Rev:B Now on Waterjet 07-01-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 		Purchased		No		100	sf	113.0000	0.105	0.663158	1.		

304/316 0.125 Sheet

Location	Loc Qty	Loc Code
MAT020	113	
117494	113	

FB11-C-21
17494

(8)

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	<i>70927</i>
Description: Fitting	Part Number:	D3198-1
Inspection Dwg: D3198 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>B</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: 11-6-21	Date: 11/06/21	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.03.13	New Issue	KJ/JLM	
B	08.05.28	Ø0.266 was Ø0.270	KJ/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

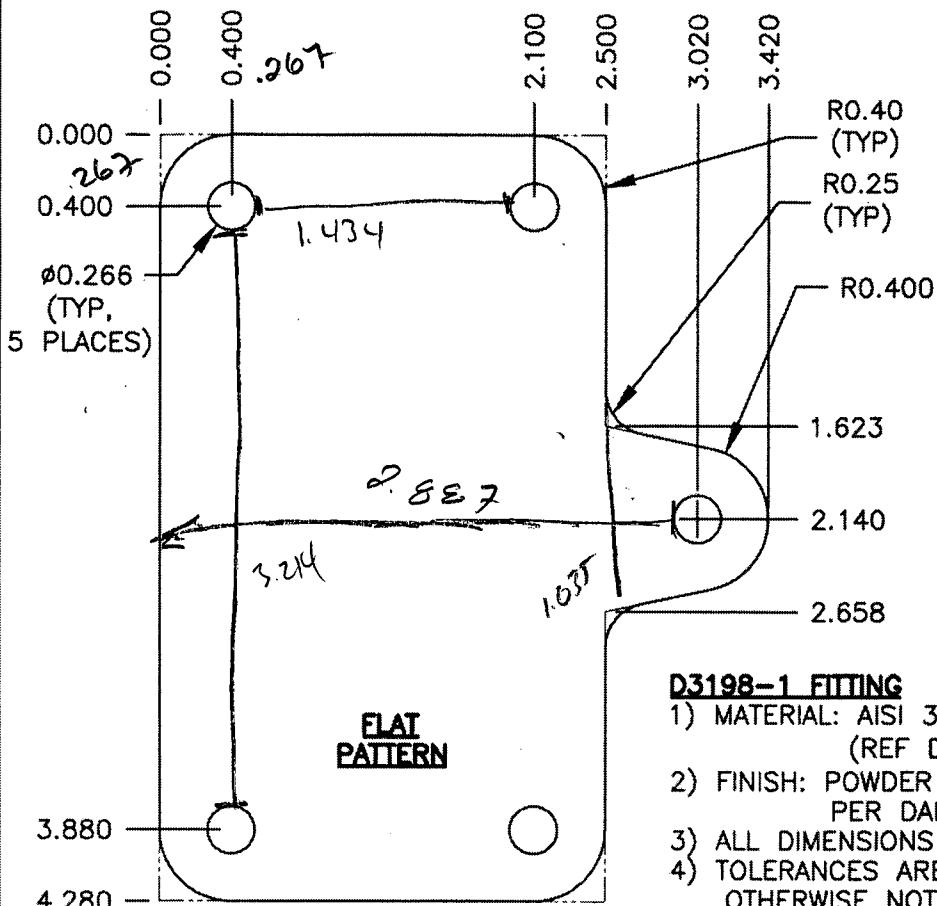
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DESIGN <i>IP</i>	DRAWN BY <i>IP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>✓</i>	APPROVED <i>✓</i>	DRAWING NO. D3198	REV. A SHEET 1 OF 1	
DATE 03.09.26		TITLE FITTING	SCALE 1:1	
A	03.09.26	NEW ISSUE		



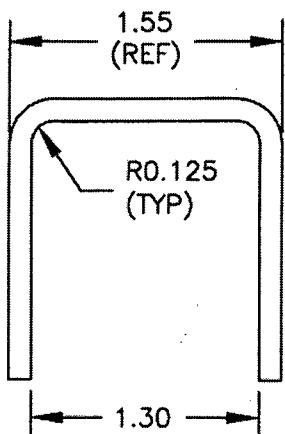
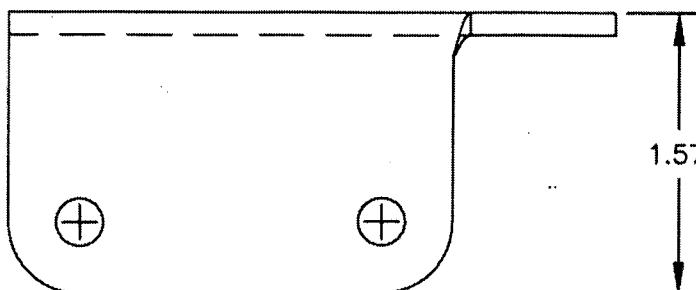
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70927

PL 11-06-17

D3198-1 FITTING

- 1) MATERIAL: AISI 304/316 SS SHEET 0.125 THICK
(REF DART SPEC. M304S11GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6)
PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

A rectangular stamp with a double-line border. The word "RELEASED" is printed in a bold, sans-serif font at the top. Below it, the date "03.10.10" is printed in a smaller font. Underneath the date is a horizontal line with a small downward-pointing arrow at the right end, intended for a signature.



BEND DETAIL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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